

Work Order ID 69343

Monday, May 09, 2011 11:36:50 AM



Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

11-5-10

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/05/11

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69343

Monday, May 09, 2011 11:36:50 AM



Page 2

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-588-011

Location: _____

PPP Rev: C11/5/16 (4)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/5/16

mf

11-0516

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Picklist Print

Monday, May 09, 2011 11:36:57 AM

Page 1

Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7 Purchased No

120

Each

76.0000

2

8



Screw

Location

Loc Qty

Loc Code

MEZZ

2

113064

1

113749

1

ST328

74

116304

74

AN526C832R8 - 1 Purchased No

120

Each

33.0000

8

32



Screw

Location

Loc Qty

Loc Code

ST327

33

116471

33

AN526C832R9 Purchased No

120

Each

603.0000

8

32



Screw

Location

Loc Qty

Loc Code

ST327

603

117010

7

117619

196

117628

400

AN960JD10 NAS1149D0363J Purchased No

120

Each

0.0000

4

16



Washer

JB

116304
32
M1176581X JB

116471 31X
32
JB

117619
16
116583 JB 11/05/11

W/O:		WORK ORDER CHANGES					
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Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD8 NAS1149DN832J Purchased No

120 Each

0.0000

24

96 ✓



Washer

D2143

Manufactured No

120 Each

31.0000

1

4 ✓



Hinge Bracket

Location

Loc Qty

Loc Code

ST198

31

64308

31

64308

D2144

Manufactured No

120 Each

20.0000

1

4 ✓



Hinge Bracket

Location

Loc Qty

Loc Code

ST198

20

64778

20

64778

D2150

Manufactured No

120 Each

9.0000

2

8 ✓



Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

9

64764

9

64764

D2151

Manufactured No

120 Each

17.0000

2

18 ✓



Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

17

64776

17

64776

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, May 09, 2011 11:36:58 AM

Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

S₇₄ D2153
Door Prop

Manufactured No

120 Each

26.0000

1 4



JB *[Signature]*

Location

Loc Qty

Loc Code

ST272

26

64943

26

64943

Manufactured No

120 Each

34.0000

1 4



JB *[Signature]*

S₇₄ D2154
Stud Bracket

Location

Loc Qty

Loc Code

ST006

34

64312

34

64312

Manufactured No

120 Each

66.0000

2 8



JB *[Signature]*

S₇₄ D2237
Striker Plate

Location

Loc Qty

Loc Code

ST009

66

64762

2

66139

64

64762 x 2

66139 x 6

Manufactured No

120 f

196.5000

7.25



30.52632

JB *[Signature]* 11/05/11

S₇₄ D2461
Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

196.5

39782

6.5

55054

4

63880

186

63880

→ measured
cut 1 X 87.00" *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, May 09, 2011 11:36:58 AM

Page 4

Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

D2463 Manufactured No 120 f 555.0600 7.25 30.52632
Seal

Location	Loc Qty	Loc Code
ST404	555.06	
64944	62.66	
66954	492.4	

64944 x 8
66954 x 2

D2583 Manufactured No 120 Each 10.0000 2
Latch Bracket

Location	Loc Qty	Loc Code
ST017	10	
66166	10	

66166
8

D2585 Manufactured No 120 Each 41.0000 2
Mounting Channel

Location	Loc Qty	Loc Code
ST017	41	
66142	41	

66142
8

D2586 Manufactured No 120 Each 107.0000 2
Door Latch

Location	Loc Qty	Loc Code
ST204	107	
64656	7	
64774	100	

64656 x 5
64774 x 3

Monday, May 09, 2011 11:36:58 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 5

Monday, May 09, 2011 11:36:58 AM

Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

S_M D2587
Door Slug, 350 Hinge

Manufactured No 120 Each 31.0000

1 4 ✓
JB

Location Loc Qty Loc Code

ST017 31
64314 4
66836 27

64314

S_M D2589
Keys, Key Chain, 350 Hinge

Manufactured No 120 Each 110.0000

1 4 ✓
JB

Location Loc Qty Loc Code

ST018 110
58194 110

58194

S_M D2690-17
Cable

Manufactured No 120 Each 22.0000

1 4 ✓
JB

Location Loc Qty Loc Code

ST020 22
64786 1
66510 21

64786 X1
66510 X3

S_M D2857-1
Hinge Bracket

Manufactured No 120 Each 1.0000

1 4 ✓
JB

Location Loc Qty Loc Code

ST024 1
64435 1

64435 X1

Monday, May 09, 2011 11:36:59 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, May 09, 2011 11:36:59 AM

Page 6

Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

D2857-2 Manufactured No

120 Each

21.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

21

64463

11

65091

10

64463

4

D2858-1 Manufactured No

120 Each

11.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64785

11

64785

4

D2858-2 Manufactured No

120 Each

11.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64787

11

64787

4

FG-778150-550-ROL Purchased No

120 sf

2,673.970

1



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

CA

1649.97

117602

1649.97

ST404

1024

104845

3

108932

18

111166

392

113905

611

113905

1- cut 1 square ft of glass cloth

Monday, May 09, 2011 11:36:59 AM

Shop Packet Print

Page 6

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Monday, May 09, 2011 11:36:59 AM

Page 7

Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

MS20426AD3-4 Purchased No

120 Each

5,258.000

12

48

✓



RIVET

Location

Loc Qty

Loc Code

ST316

5258

104374

1258

110398

4000

104374

MS20470AD4-5 Purchased No

120 Each

1,533.000

18

72

✓



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1533

116410

14

116893

1519

116893

MS21042L08' Purchased No

120 Each

303.0000

18

72

✓



Nut

Location

Loc Qty

Loc Code

ST300

303

117087

6

117441

97

117601

200

117441

MS21042L3 Purchased No

120 Each

2,400.000

4

16

✓



Nut

Location

Loc Qty

Loc Code

ST300

2400

116391

11

116540

423

116549

766

117441

800

117601

400

116540

Monday, May 09, 2011 11:36:59 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 8

Monday, May 09, 2011 11:36:59 AM

Work Order ID: 69343

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

MS27039-08-11

Purchased

No

120

Each

183.0000

2

8 ✓



Screw

Location

Loc Qty

Loc Code

ST290

183

116289

33

117441

150

116289

MS27039-1-15

Purchased

No

120

Each

100.0000

2

8 ✓



Screw

Location

Loc Qty

Loc Code

ST292

100

116916

100

116916

JB

11/05/11

Monday, May 09, 2011 11:36:59 AM

Shop Packet Print

Page 8

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

REFERENCE ONLY

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

